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DART AEROSPACE LTD		Work Order:	19536
Description: Long Step Assembly - High Skid, RH		Part Number:	704A 41 640 007
D350-591-212			
Dwg: D3070 Rev. A1		Qty:	10
RF 02-11-13		Page 1 of 2	

Step	Location	Procedure	By	Date	Qty																
1	DC	Issue Traveller Dwg not required	HA	03.08.29	10																
2	DC	Photocopy bluefile and type labels per PPP 704A 41 640 007 CHG001 CHG002 WK 45 HA	HA	04.03.12	10																
3	GA	Cut D2622-120C extrusion to 116.25" long as per Dwg D3070 using cutting table setup DT8185-2A Pick: <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>1</td><td>D2622-120C</td><td>Extrusion</td><td>B18809</td></tr></table> Ensure wall thickness is 0.070 to 0.090	Qty	Part Number	Description	Batch	1	D2622-120C	Extrusion	B18809	SB	04/03/03	10								
Qty	Part Number	Description	Batch																		
1	D2622-120C	Extrusion	B18809																		
4	GA	Drill extrusion per Dwg D3070 using Jig DT8680 for rivets.	SB	04/03/03	10																
5	GA	Deburr	SB	04/03/03	10																
6	QC5	Inspect work to Step 5	MA	04/03/03	10																
7	WA	Bevel end for welding FWD ONLY	MA	04/03/03	10																
8	WA	Weld Support using Jig DT8681, weld Fwd End Plate per QSI 004 & Dwg D3070 Pick: <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>1</td><td>D3063-1</td><td>Support</td><td>B19555</td></tr><tr><td>1</td><td>D3067-1</td><td>End Plate</td><td>B19558</td></tr><tr><td>A/R</td><td></td><td>Aluminum Rod</td><td>M13066</td></tr></table>	Qty	Part Number	Description	Batch	1	D3063-1	Support	B19555	1	D3067-1	End Plate	B19558	A/R		Aluminum Rod	M13066	MA	04/03/03	10
Qty	Part Number	Description	Batch																		
1	D3063-1	Support	B19555																		
1	D3067-1	End Plate	B19558																		
A/R		Aluminum Rod	M13066																		
9	GA	Grind End Plate flush	SB	04/03/04	10																
10	QC9	Inspect weld and work to Step 9	MA	04/03/05	10																
11	FP	Chemical conversion coat as per QSI 005 4.1	MA	04.03.08	10																
12	GA	Assemble Leg Assembly as per Dwg D3070. D3066-1 are done with Step Leg Assy, don't add to the BOM. RF 03.01.13 Pick: <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>1</td><td>D3065-041</td><td>Step Leg Assy</td><td>B19557</td></tr><tr><td>2</td><td>D3066-1</td><td>Spacer</td><td>B19557</td></tr><tr><td>16</td><td>MS20600AD4W4</td><td>Rivet</td><td>M13767</td></tr></table>	Qty	Part Number	Description	Batch	1	D3065-041	Step Leg Assy	B19557	2	D3066-1	Spacer	B19557	16	MS20600AD4W4	Rivet	M13767	MA	04-03-15	10
Qty	Part Number	Description	Batch																		
1	D3065-041	Step Leg Assy	B19557																		
2	D3066-1	Spacer	B19557																		
16	MS20600AD4W4	Rivet	M13767																		
13	QC5	Inspect work to step 12	MA	04/03/16	10																
14	WA	Bevel Aft end for welding	MA	04/03/16	10																
15	WA	Inspect for foreign object per QSI 024	MA	04/03/16	10																
16	WA	Weld Aft End Plate per QSI 004 & Dwg D3070 Pick: <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>1</td><td>D3067-1</td><td>End Plate</td><td>B19558</td></tr><tr><td>A/R</td><td></td><td>Aluminum Rod</td><td>M13066</td></tr></table>	Qty	Part Number	Description	Batch	1	D3067-1	End Plate	B19558	A/R		Aluminum Rod	M13066	MA	04/03/16	10				
Qty	Part Number	Description	Batch																		
1	D3067-1	End Plate	B19558																		
A/R		Aluminum Rod	M13066																		

BB 04-03-25 AB

POSITIVE RECALL

EFFECTIVE 04.03.15 AUTH

RELEASED

DATE 04.03.16 03.06.06 RF

CANCELLED FORM 16

UNDER REVIEW

See Dwg

RELEASED
02/11/01 RF

STEP 11 NCR 748 MA Complete 04.03.16 AB
Step 12
POSITIVE RECALL

Dart Aerospace Ltd

Work Order:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR # 748		WORK ORDER NON-CONFORMANCE						
DATE	STEP	Description of NC section A	Initial	Corrective Action Section B	Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
04-03-12	11	The Step was not HOMOGENE colour "Poor Quality"	ml	Re do step 11	ml 04-03-12	SB 04/03/16	# 04.03.16	 04/03/16

PAR#: N/A

Fault Category: N/A

DQA: N/A

Date: 04.03.29

NOTE: Date & initial all entries
H:\Admin-QA\ISO\forms\w\oncb.doc

QA: N/C Closed: N/A

Date: N/A

DART AEROSPACE LTD		Work Order:	19536
Description: Long Step Assembly – High Skid, RH D350-591-212		Part Number:	704A 41 640 007
Dwg: D3070 Rev. A1		Qty:	10
		Page 2 of 2	

17	GA	Grind End Plate flush	SB	04/03/16	10																																																				
18	QC9 & 5	Inspect work to Step 17 – Check dimension 140.56" from Dwg D3070 110.71" RF 02.11.13	SB	04/03/16	10																																																				
19	FP	Powder Coat Gloss White (Ref: 4.3.5.1) per QSI 005 4.3	SB	04.03.22	10																																																				
20	FP	Wing Walk per Dwg D3070 and QSI 005 4.4 M14087	SB	04.03.22	10																																																				
21	QC3	Inspect Powder Coat and Wing Walk	SB	01.03.23	10																																																				
22	KP	Pick: Packing Kit <table><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>4</td><td>D2182B035</td><td>Rubber Cushion</td><td>B20434</td></tr><tr><td>8</td><td>D2274</td><td>Radius Block</td><td>B20207</td></tr><tr><td>2</td><td>D2856-400-720</td><td>Abrasion Strip</td><td>B19645</td></tr><tr><td>2</td><td>D3064-1</td><td>Clamp</td><td>B20123</td></tr><tr><td>1</td><td>D3070-041</td><td>Support Assy</td><td>B20456</td></tr><tr><td>4</td><td>D3080-1</td><td>Clamp</td><td>B19559</td></tr><tr><td>2</td><td>AN3-35A</td><td>Bolt</td><td>M13943/M12597</td></tr><tr><td>10</td><td>AN4-11A</td><td>Bolt</td><td>M13735/M12963</td></tr><tr><td>4</td><td>AN960JD10</td><td>Washer</td><td>M13441</td></tr><tr><td>20</td><td>AN960JD416</td><td>Washer</td><td>M13356/M13719</td></tr><tr><td>2</td><td>MS21042L3</td><td>Nut (or -3)</td><td>M14019</td></tr><tr><td>10</td><td>MS21042L4</td><td>Nut (or -4)</td><td>M13276/M12620</td></tr></tbody></table>	Qty	Part Number	Description	Batch	4	D2182B035	Rubber Cushion	B20434	8	D2274	Radius Block	B20207	2	D2856-400-720	Abrasion Strip	B19645	2	D3064-1	Clamp	B20123	1	D3070-041	Support Assy	B20456	4	D3080-1	Clamp	B19559	2	AN3-35A	Bolt	M13943/M12597	10	AN4-11A	Bolt	M13735/M12963	4	AN960JD10	Washer	M13441	20	AN960JD416	Washer	M13356/M13719	2	MS21042L3	Nut (or -3)	M14019	10	MS21042L4	Nut (or -4)	M13276/M12620	CP	04/03/04	10
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23	QC4	Inspect 100% Kit for Completeness on the W/O	CP	04.03.25	10																																																				
24	PK	Package for shipping as per PPP 704A 41 640 007 Rev. A	CP	04/03/25	10																																																				
25	AC	Cost / part 239.30	545	04.03.29	10																																																				
26	DC	Close W/O 239.30 Inspect Level 21	SB	04.03.29	10																																																				

Rev	Date	Change	Revised By	Approved
A	02.11.01	New issue	KJ RF	SB
A1	03.01.14	110.71" was 110.56" ; Dwg. Rev. A1	RF	SB
A2	03.07.16	D3194-041 was D3070-041 ; CHG002	RF	SB

UNDER REVIEW

03.06.06 RF

See David

CANCEL RF 03.01.16

RELEASED
02/11/02

Dart Aerospace Ltd

Work Order:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR		WORK ORDER NON-CONFORMANCE						
DATE	STEP	Description of NC section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial					

PAR#: _____ Fault Category: _____ DQA: _____ Date: _____

NOTE: Date & initial all entries
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QA: N/C Closed: _____ Date: _____

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Aug 27, 2003
02:05 pm

Work Order No	: 0019536	Department Code:	
Project Name	: *704A 41 640 007	Burden Flags	: NNNNNNN
Project For	: WK347	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: *704A 41 640 007	Invoice Number	:
Description	: Heli-Access-Step,Long RH	Invoice Amount	: 0.00
Manufactured	: Yes		
Amount Req'd	: 10	Order Entry No	:
Amount Done	: 0	OE Value	: 0.00
Start Date	: 08-27-03		
Est Finish Date	: 11-28-03	Est Margin	: 0.000%
Act Finish Date	:	Actual Margin	: 0.000%
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:	\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Testing Hours	0.00	0.00	0.00		
Testing Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
SubContract Hours	0.00	0.00	0.00		
SubContract	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Margin	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00

